

5th of April

Work Order ID 67713

Tuesday, March 29, 2011 1:11:10 PM



Item ID: D4151-5

Accept



Setup Start



Revision ID:

Item Name: Fwd Basket Instl Stud

Stop



Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4151

C

110

0.00



Doosan

Doosan Lathe

Memo

1-Mill as per folio FA953 & dwg,
FOLIO REV: NA
DWG REV: NA

2-GRIND .13" RAD MANUALLY

3-Deburr as required

0.00

ml 11.3.30

4

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

ml 11.3.30

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67713

Tuesday, March 29, 2011 1:11:11 PM



Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

amb 11/03/31

4

0

140

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

w/o 67656 (42) 0.00

Packaging

ES 11/03/31 (4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31

ME

11-03-31

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:11:06 PM

Page 1

Work Order ID: 67713



Parent Item: D4151-5



Parent Item Name: Fwd Basket Instl Stud

Start Date: 3/29/2011

Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B
11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 		Purchased		No		110	f	13,5400	0.25	1.052632			

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

13.54

116700 ✓

13.54

993

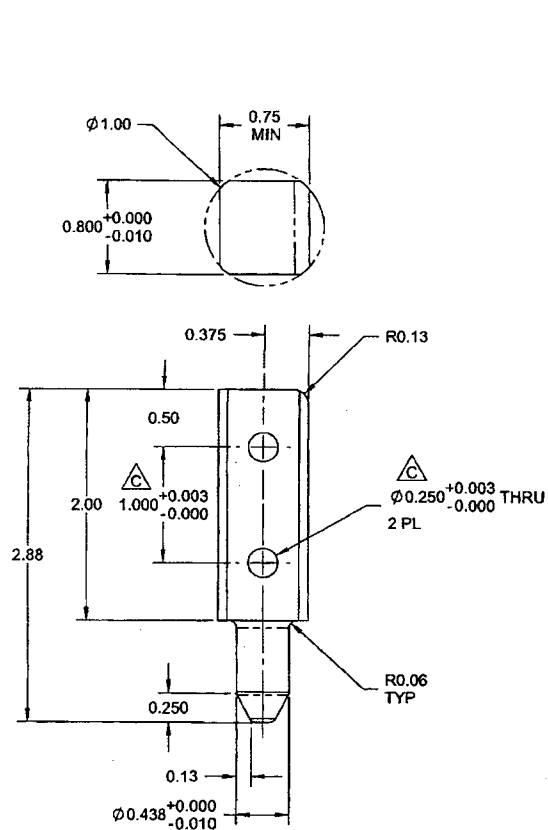
W/O:		WORK ORDER CHANGES						
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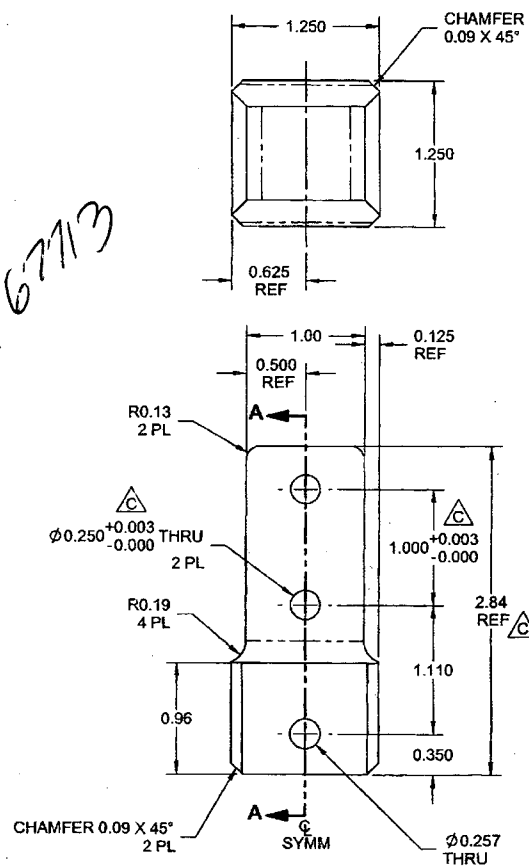
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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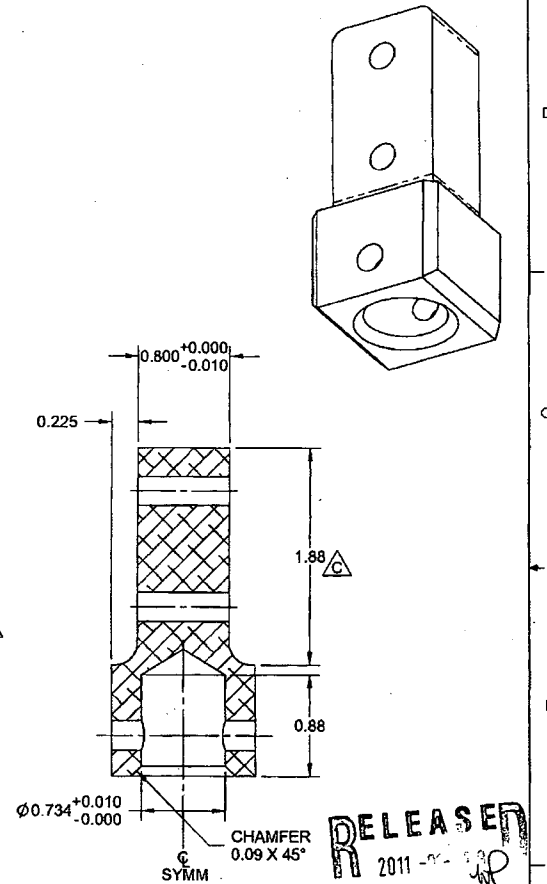
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

- NOTES:**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
 - 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE
DE APPR.			NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67113
Description: Prod Basket msl/H foot (lower)		Part Number: 04151-7
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00 ϕ	$\pm .030$.999	/		2Q.02	
.75	$\pm .03 - 0.0$.756	/			
.800	$\pm 0.0 - .010$.796	/			
.375	$\pm .010$.375	/			
R.13	$\pm .030$.130	/			
.50	$\pm .030$.502	/			
2.00	$\pm .030$	2.002	/			
1.000	$\pm .003 - 0.0$	1.001	/			
.250 ϕ	$\pm .003 - 0.0$.250	/			
2.88	$\pm .030$	2.881	/			
.250	$\pm .010$.249	/			
2.06	$\pm .030$	2.070	/			
.13	$\pm .030$.130	/			
.438	$\pm 0.0 - .010$.435	/			

Measured by: <i>[Signature]</i>
Date: 11-3-30

Audited by: <i>[Signature]</i>
Date: 11/03/31

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	